



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

PRELIMINARY ISSUE

650.6313

Job Sheet 211154



Part No: 650.6313

Job Qty: 3 pcs

DAS
21
9-89

Part Name: Screen



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/7/20

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 7/16/20

Type: Stock

Description:

Note: 650.6300 REV.PG2 IPP REV:A 20.06.15 NEW ISSUE DD VERF:JFS

Ship Via:

139 Valve

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	3 pcs	7/16/20	7/16/20	0.17	0.05	Waterjet - Flow		on 20/07/22
							Waterjet - Omax		
110	QC 2	3 pcs	7/16/20	7/16/20	0.00	0.00	QC 2 - 1		on 20/07/22
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120 QC 8	3 pcs	7/16/20	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
130 Packaging 3-1 - Stock - B4B	3 pcs	7/16/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	

DAS
81
9-89
DAS
82
9-89

JUL 23 2020

				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140	QC 21 - SA	3 pcs	7/16/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 9
					AUG 2 5 2020

Part Op **100** - 1-Cut as per Dwg Dwg Rev: AG-2 Prog Rev: PG-2 2-Deburr if necessary
 Descriptions: **110** - QC2- Inspect parts off machine FAI/FAIB
120 - (QC8- Inspect parts - second check)
130 - (Identify as per dwg & Stock Location: _____)
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304PS0.030X0.063X0.094-STA-41 <u>9358122</u>	304 Perforated Sheet	.0036 (.0012 ea)	100-Waterjet - Flow - 1	<u>S 283443</u>

Job Allocations

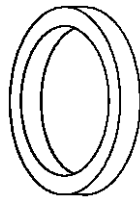
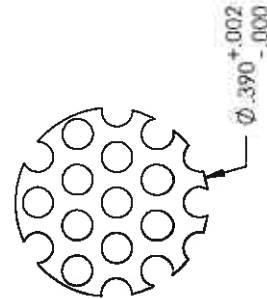
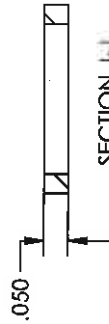
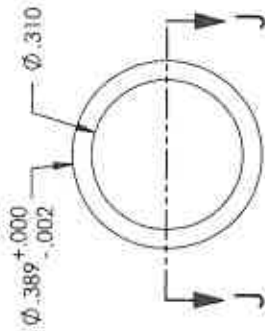
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304PS0.030X0.063X0.094-STA-41	0	0 ✓	0

Part Specifications

Specifications could not be found.

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 WITHOUT THE WRITTEN PERMISSION OF ARTCO INDUSTRIES, INC. (ARTCO).



650.6312



650.6313

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. ~~210863~~ *JK*
 211154

ARTCO 3000 ENGINEERING CT SUITE 200 HICKORY, NC 28626 (704) 754-6300	
PROJECT NO. DRAWING NO. SCALE DATE	650.6312 650.6313 1:1 6/16/2020
SWIVEL FITTING	
PART NAME PART NO. QUANTITY UNIT	650.6312 650.6313 1 EACH

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

DISPOSITION		DEPARTMENT/PROCESS																																																													
Job: _____	Rework ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐																																																											
Part No. _____	Scrap ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐																																																											
	Use-as-is ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐																																																											
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042) ☐																																																											
Description Work Order Deviation		Disposition																																																													
Root Cause <table border="1"><tr><td>Operator</td><td>☐</td></tr><tr><td>Manufacturing Process</td><td>☐</td></tr><tr><td>Equip/Tooling</td><td>☐</td></tr><tr><td>Handling/Preservation</td><td>☐</td></tr><tr><td>Material</td><td>☐</td></tr><tr><td>Product Improvement</td><td>☐</td></tr><tr><td>Process Improvement</td><td>☐</td></tr><tr><td>Human Factors</td><td>☐</td></tr></table>		Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY <table border="1"><tr><td>Contamination</td><td>☐</td><td>Power Loss/Surge</td><td>☐</td><td>Positioned Wrong</td><td>☐</td></tr><tr><td>Misaligned/off center</td><td>☐</td><td>Folio/Program</td><td>☐</td><td>Outside Tolerance</td><td>☐</td></tr><tr><td>BOM/Route</td><td>☐</td><td>Grain Direction</td><td>☐</td><td>Drawing</td><td>☐</td></tr><tr><td>Broken/Damage/Defect</td><td>☐</td><td>Weld</td><td>☐</td><td>Finish</td><td>☐</td></tr><tr><td>Incomplete/Unclear Instructions</td><td>☐</td><td>Wrong Stock Pulled</td><td>☐</td><td>Part Lost/Missing</td><td>☐</td></tr><tr><td>Drill Holes</td><td>☐</td><td>Out of Sequence</td><td>☐</td><td>Misread</td><td>☐</td></tr><tr><td>Fit/Function</td><td>☐</td><td>Off-set/Set-up</td><td>☐</td><td></td><td></td></tr></table>				Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐	Fit/Function	☐	Off-set/Set-up	☐		
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Drill Holes	☐	Out of Sequence	☐	Misread	☐																																																										
Fit/Function	☐	Off-set/Set-up	☐																																																												
Other/Details: _____																																																															
Completed By		Lead hand / Supervisor																																																													
		QC / QA Coordinator																																																													



Dart Aerospace Ltd.
1270 Aberdorn Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 513 632-5200
Email: sales@dartaero.com
www.dartaero.com

Container No: S289591



Part: 650.6313

Job No: 211154

Serial No/Batch: S289591

Revision: REV.PG2

Inspector:

Exp Date:

Instructions:

Date: 07/22/10

200 Aurora Industrial Pkwy
Aurora OH 44202-6087
330-395-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K3A 1K7
Canada

Purchase Order
POHB046616

Order Placed By
Kim

McMaster-Carr Number
6877038-01

Page 1 of 1

06/17/2020

Packing List

Line	Product	Ordered	Shipped
1	304 Stainless Steel Perforated Sheet, Staggered, 0.03" Thick, 0.0625" Diameter, 41% Open, 24" X 24"	1 Each	1

Shipped separately from our Cleveland warehouse on 06/17

2	92210A303 18-8 Stainless Steel Hex Drive Flat Head Screw, 10-32 Thread Size, 5/8" Long	1 Pack	1
3	94355A330 18-8 Stainless Steel Flat-Tip Set Screws, 10-32 Thread, 1/4" Long	2 Packs	2
4	91257A745 Zinc Yellow-Chromate Plated Hex Head Screw, Grade 8 Steel, 1/2"-20 Thread Size, 3-1/4" Long	1 Pack	1
5	6121K14 Black-Oxide Steel Knurled Grip Knob with 1/4"-28 Threaded Hole, 1" Head Diameter	3 Each	3
6	90905A873 316 Stainless Steel Split Ring, 1-1/16" OD	1 Pack	1
7	97484A341 Large-Diameter Low-Profile Dorned Head Solid Rivets, 1/4" Diameter, for 0.25" Maximum Material Thickness	1 Pack	1
8	98381A550 Dowel Pin, 4037 Alloy Steel, 1/4" Diameter, 2" Long	1 Pack	1
9	6987K14 Brass Submersible Cord Grip, NPT Thread, for 0.24"-0.47" Cord OD, 1/2 Knockout Size	5 Each	5
10	9529K15 Hardened Bearing-Quality 440C Stainless Steel Ball, 1/4" Diameter	4 Packs	4

Certificate of compliance

This is to certify that the above items were supplied in accordance with the description and as illustrated in the catalog. Your order is subject only to our terms and conditions, available at www.mcmaster.com or from our Sales Department

Hbox

Purch# C/PK 007869298

RECEIVED

JUN 18 2020

DART AEROSPACE LTD.

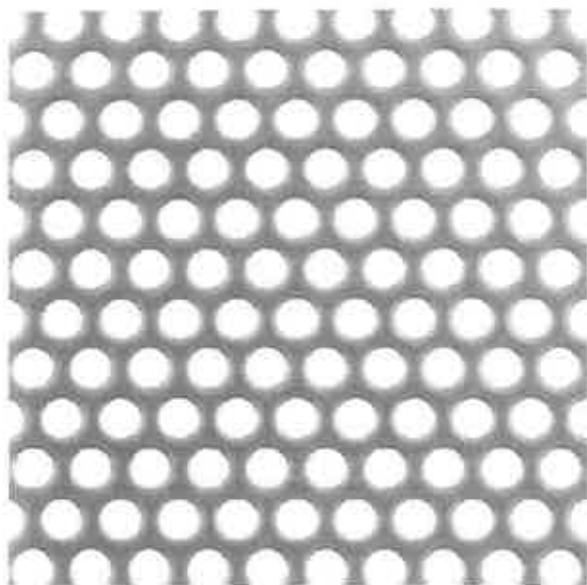
Sarah Weinberg

Sarah Weinberg
Compliance Manager

McMASTER-CARR.**304 Stainless Steel Perforated Sheet**

Staggered Holes, 0.03" Thick, 0.0625" Diameter, 41% Open Area

9358T22



Shape	Sheet
Form	Sheet
Construction	Perforated
Hole Pattern	Staggered
Thickness	0.03"
Gauge	22
Hole Diameter	0.0625"
Open Area	41%
Hole Center-to-Center	0.094"
Material	304 Stainless Steel
Sheet Size	24" x 24", 36" x 40", 48" x 48"
RoHS	RoHS 3 (2015/863/EU) Compliant
REACH	REACH (EC 1907/2006) (01/16/2020, 205 SVHC) Compliant

304 stainless steel has good corrosion and abrasion resistance as well as weldability and formability. It's often used in chemical and food-processing equipment.

S283443

SPECIFICATION CONTROL DRAWING

PURCHASE MATERIAL: AISI 304 STAINLESS STEEL PERFORATED SHEET

PART NUMBER: M304PS [T.TTT] X [H.HH] X [C.CCC] - [HP]

WHERE "T.TTT" = SHEET THICKNESS IN INCHES
"H.HH" = HOLE DIAMETER IN INCHES
"C.CCC" = HOLE CENTER TO CENTER IN INCHES
"HP" = HOLE PATTERN, STAGGERED [ST] OR STRAIGHT [STR]

PART NUMBER	[T.TTT] SHEET THICKNESS	[H.HH] HOLE DIAMETER	[C.CCC] HOLE CENTER TO CENTER	[HP] HOLE PATTERN	PERCENT OPEN AREA	SUGGESTED VENDOR	SUGGESTED VENDOR/PIN
M304PS0.030X0.063X0.094-ST/A	0.030	0.063	0.094	STAGGERED	41%	MCMASTER-CARR	83581722 OR 83581281

RELEASED

2020 AUG 20 ✓
H3 2478-13

APPROVED

A	NEW ISSUE	DESCRIPTION	KPT	DATE
REV.			BY	DATE
DESIGN	KPT	DESIGN NO.		
DRAWN	KPT	DART AEROSPACE LTD		
CHECKED	ML	HAINESBURY, ONTARIO, CANADA		
MFG. APPR.	SH	M304PS		
APPROVED	ML	TITLE		
DE APPR.	CP	304 PERFORATED SHEET		
DATE	20.06.24	SCALE		
		NTS		

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